



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

654.3910

Job Sheet 207545



PRIORITY

Part No: 654.3910

Job Qty: 7 pcs

Part Name: Handle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/20

Job Tracking No:

Due Date: 3/16/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG 654.3900 REV N/C IPP REV A 20.02.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 5 Axis	7 pcs			0.75	2.80	HAAS - 1 - 5 - B4B		20-03-03
							HAAS - 2 - 5 - B4B		
110	QC 2	7 pcs			0.00	0.00	QC 2 - 1		20-03-04
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S260937



Part: 654.3910

Job No: 207545

Serial No/Batch: S260937

Revision: N/C

Inspector:

Exp Date:

Instructions:

Date: 03/04/20

			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
120 QC 8	7 pcs	0.00 0.00	QC 8 - 12	
			QC 8 - 14	7/20/03/05
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
125 Outsource - 4 - Anodize	7 pcs		GRO002-VC ATG001	2020-03-05
130 Packaging 2-1 - Receive - B4B	7 pcs	0.00 0.00	Packaging 2 - 1 - B4B	
			Packaging 2 - 2 - B4B	
			Packaging 2 - 3 - B4B	
			Packaging 2 - 5 - B4B	1/1 MAR 1 1 2020
			Packaging 2 - 4 - B4B	
			Packaging 2 - 6 - B4B	
			Packaging 2 - 7 - B4B	
			Packaging 2 - 8 - B4B	
			Packaging 2 - 9 - B4B	
			Packaging 2 - 10 - B4B	
			Packaging 2 - 11 - B4B	
			Packaging 2 - 12 - B4B	
			Packaging 2 - 13 - B4B	
			Packaging 2 - 14 - B4B	
			Packaging 2 - 15 - B4B	
			Packaging 2 - 16 - B4B	
			Packaging 2 - 17 - B4B	
			Packaging 2 - 18 - B4B	
			Packaging 2 - 19 - B4B	
			Packaging 2 - 20 - B4B	
			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	

			Packaging 2 - 26 - B4B	
			Packaging 2 - 27 - B4B	
			Packaging 2 - 28 - B4B	
			Packaging 2 - 29 - B4B	
			Packaging 2 - 30 - B4B	
			Packaging 2 - 31 - B4B	
			Packaging 2 - 32 - B4B	
			Packaging 2 - 33 - B4B	
			Packaging 2 - 34 - B4B	
			Packaging 2 - 35 - B4B	
			Packaging 2 - 36 - B4B	
			Packaging 2 - 37 - B4B	
140	QC 6	7 pcs	0.00 0.00	QC 6 - 9
				QC 6 - 68
				QC 6 - 61
				QC 6 - 40
				QC 6 - 81
210	Packaging 3-1 - Stock - B4B	7 pcs	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
				Packaging 3 - 37 - B4B
220	QC 21 - SA	7 pcs	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 53

DAS
81
9-89

MAR 11 2020

DAS
28
9-89

DAS
21
9-89

MAR 12 2020

GA217

Part Op 100 - 1-Machine as per folio FD187 FOLIO REV: AA DWG REV: N/C 2-Debur
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

125 - Issue P/O; 46026 -ANODIZE COLOR RED, PER IAW MPP-172 Section 2.2 -Material type; 6061T6 -
Certificate of Conformity is required

130 - (Receive & Inspect for Damage & Mat'l Certs) C of C required.

140 - QC6- All purchased or subcontracted products

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	2.5970 ft (.371 ea)	100-HAAS 5 Axis	<u>S240 677</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 5 Axis	M6061T6B1.000X02.000	3	15	0

Part Specifications

Specifications could not be found.

Plex 2/27/20 1:20 PM dart.lacelle.linda

DART AEROSPACE LTD		Work Order: 207.545
Description: Hamelle		Part Number: 654.3910
Inspection Dwg: 654.3900 Rev: N/C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.190	+0.005/-0.001	.190	✓		gauge	PIN
.23	+/- .010	.228	✓		Height gauge	
.24	+/- .010	.239	✓		"	
.55	+/- .010	.5535	✓		"	
R.23	+/- .010	.230	✓		Rad gauge	
Ø.202	+0.005/-0.001	.204	✓		gauge	PIN
Ø.195	+0.005/-0.001	.198	✓		"	
1.09	+/- .010	1.090	✓		Height gauge	
1.25	+/- .010	1.246	✓		"	
1.35	+/- .010	1.350	✓		"	
1.86	+/- .010	1.860	✓		"	
R3.00	+/- .010	3.000	✓		Rad gauge	
4.05	+/- .010	4.046	✓		Height gauge	
.230	+/- .005	.235	✓			
.658	+/- .005	.653	✓			
.755	+/- .005	.751	✓			
.846	+/- .005	.841	✓			
1.149	+/- .005	1.148	✓			
1.262	+/- .005	1.260	✓			
1.74	+/- .010	1.735	✓			
233.8°	+/- .5°	233.8°	✓		Protractor	
225°	+/- .5°	225°	✓		"	
R.19	+/- .010	.190	✓		Rad gauge	
.39	+/- .010	.388	✓		SL10	VERN
.58	+/- .010	.581	✓		"	
86°	+/- .5°	86°	✓		Protractor	
R.13	+/- .010	.130	✓		Rad gauge	
1.57	+/- .010	1.570	✓		Height gauge	
1.05	+/- .010	1.050	✓			
.073	+/- .005	.070	✓			
.573	+/- .005	.571	✓			
.645	+/- .005	.646	✓			

Measured by: 20 9-99	Checked by:	QC Inspector:
Date: 20-03-04	Date:	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

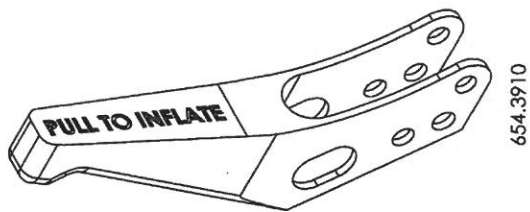
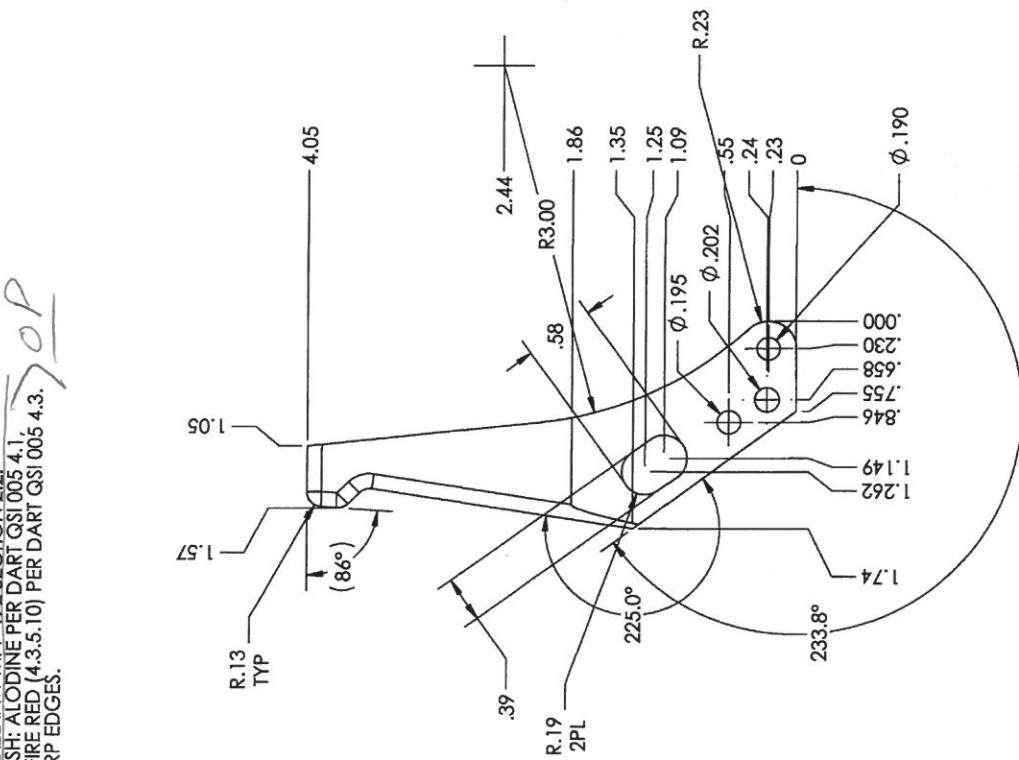
Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DDA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DDA DART AEROSPACE IS PROHIBITED.

NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 6061-T6
2. FINISH: RED ANODIZE IAW MPP-172 SECTION 2.2
3. ALTERNATIVE FINISH: ALODINE PER DART QSI 005 4.1,
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3.
4. DEBURR ALL SHARP EDGES.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	02-21-2020	A. QUAN

[illegible]

DART
AEROSPACE
APCAL INDUSTRIES, INC.
4000 DART AEROSPACE
3030 ENTERPRISE CT.,
SUITE A
VISTA, CA. 92081
(760)-724-5300

HANDLE ASSY		REV.	
SIZE	CAGE CODE	DWG. NO.	
B	07M26	654.3900	N/C
SCALE NONE		SHEET 1 OF 1	

5/17/2015



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046026



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046026

PO Date: 3/5/20

Due Date: 3/20/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-03-11

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205058	647.1714	647.1700 Rev A	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize and Prime as Per Dwg 647.1700 Rev. E	Firmed	-	3/18/20	49 pcs	0 pcs	49 pcs	\$31.15/pcs	\$1,526.35
2	205059	647.1715	647.1700 Rev E	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.1700 Rev. E	Firmed	-	3/18/20	30 pcs	0 pcs	30 pcs	\$31.15/pcs	\$934.50



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046026



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	205046	646.9811	646.9800 Rev A	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed	-	3/20/20	8 pcs	0 pcs	8 pcs	\$33.50/pcs	\$268.00
4	204004	C45-9-1	C45-9-1 Rev 6	Clock Spring Cover -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Material type 6061T6 -Certificate of Conformity is required	Firmed	-	3/20/20	20 pcs	0 pcs	20 pcs	\$5.59/pcs	\$111.80
5	205071	647.7612	647.7600 Rev N/C	Breakaway Tip : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed	-	3/20/20	8 pcs	0 pcs	8 pcs	\$11.60/pcs	\$92.80

MAR 11 2020



Grand Total: \$3,155.93

Khérin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046026



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/11/20 11:34 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919768

Date: 11-Mar-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: C45-9-1 Clock Spring Cover Anodize Black, per IAW MIL-A_8625F Type 2, Class 2, Water Sealant Job: 27064 PO: POHB046026	Rev: 6	
7 ea	Part: 654.3910 Handle Anodize Red, per IAW MPP-172 Section 2.2 Job: 27066 PO: POHB046026	Rev: N/C	Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 11 2020</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

DAS
81
9-89

RECEIVED

MAR 11 2020

DART AEROSPACE LTD.